$((1+\delta_{1})_{1}, \dots, \delta_{n})_{1}(\mathcal{X}_{n}, \mathcal{X}_{n}) = (1+\delta_{1})_{1}(1+\delta_{2})$

and the second of the second

ABSTRACT OF THE DISCLOSURE

A gap (34) for forming an excess thickness portion is provided between a pair of first dies (26, 27) and a intermediate portion (32) of the second die (24), and an excess thickness portion (35) is formed in bottom portions of the valve guide walls (28, 29) of valve guide walls.